

**Work Order ID** 56699

Page 1

March 4, 2010 12:43:06 PM

Item ID: D3709-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle

Start Date: 3/05/10 Start Qty: 5.00



Cust Item ID:

Required Date: 3/12/10 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: *R* QC: \_\_\_\_\_

Date: 10-3-04

Tooling: Date: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3709	Rev A

100 Waterjet FLOW WATER JET



Memo 0.00

FLOW CNC Waterjet

I-Cut as per Dwg D3709 I Dwg Rev: *A* I Prog Rev: *A*

6061. 063

\*\*\*\*grain direction on a 45 degree \*\*\*\*  2- Deburr if  
necessary

*B 10-3-10**(7)*

110 QC2- Inspect parts off machine FAI/FAIB 0.00



Memo 0.00

Quality Control

*B 10-3-10*

120 QC8- Inspect parts - second check 0.00



Memo 0.00

Quality Control

*S 10-3-10**(X7)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 56699**

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March 4, 2010 12:43:11 PM

Item ID: D3709-1

Accept



Setup Start



Revision ID:

Item Name: Angle

Stop



Start Date: 3/05/10 Start Qty: 5.00



Cust Item ID:

Required Date: 3/12/10 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center ID

130

Operation  
Description

Small Fab

Set Up/  
Run Hours

0.00

Draw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Small Fab

Small Fab

Memo

Form as per dwg D3709

SB 10/04/15

7 0

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8 10/04/16

(X7)

150



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

M 10/04/19

X7 0

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 56699**

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March 4, 2010 12:43:12 PM

Item ID: D3709-1

Accept



Setup Start



Revision ID:

Item Name: Angle

Stop



Start Date: 3/05/10

Start Qty: 5.00



Cust Item ID:

Required Date: 3/12/10

Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC3- Inspect Part Finish

0.00

(7)

PR 104-19

QC

Memo

0.00

Quality Control

170



Identify as per dwg &amp; Stock Location: 169

0.00

PC 10/04/20(7)

Packaging

Memo

0.00

Packaging

180



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/04/20ff

MF  
10-4-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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March 4, 2010 12:40:27 PM

Work Order ID: 56699



Parent Item: D3709-1



Parent Item Name: Angle

Start Date: 3/05/10

Required Date: 3/12/10

Comments: IPP Rev:A 08-10-31 new issue DD verified by:EC

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased		No			sf	295.7841	14000	2	18.10-3-10	

6061T6 .063 Sheet



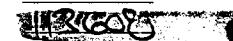
## Warehouse

### Location

Main Warehouse

MAT	295.7841211
110551	18.1841211
113608	277.6

(7)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	56699
Description: Angle	Part Number:	D3709-1
Inspection Dwg: D3709 Rev: A		Page 1 of 1

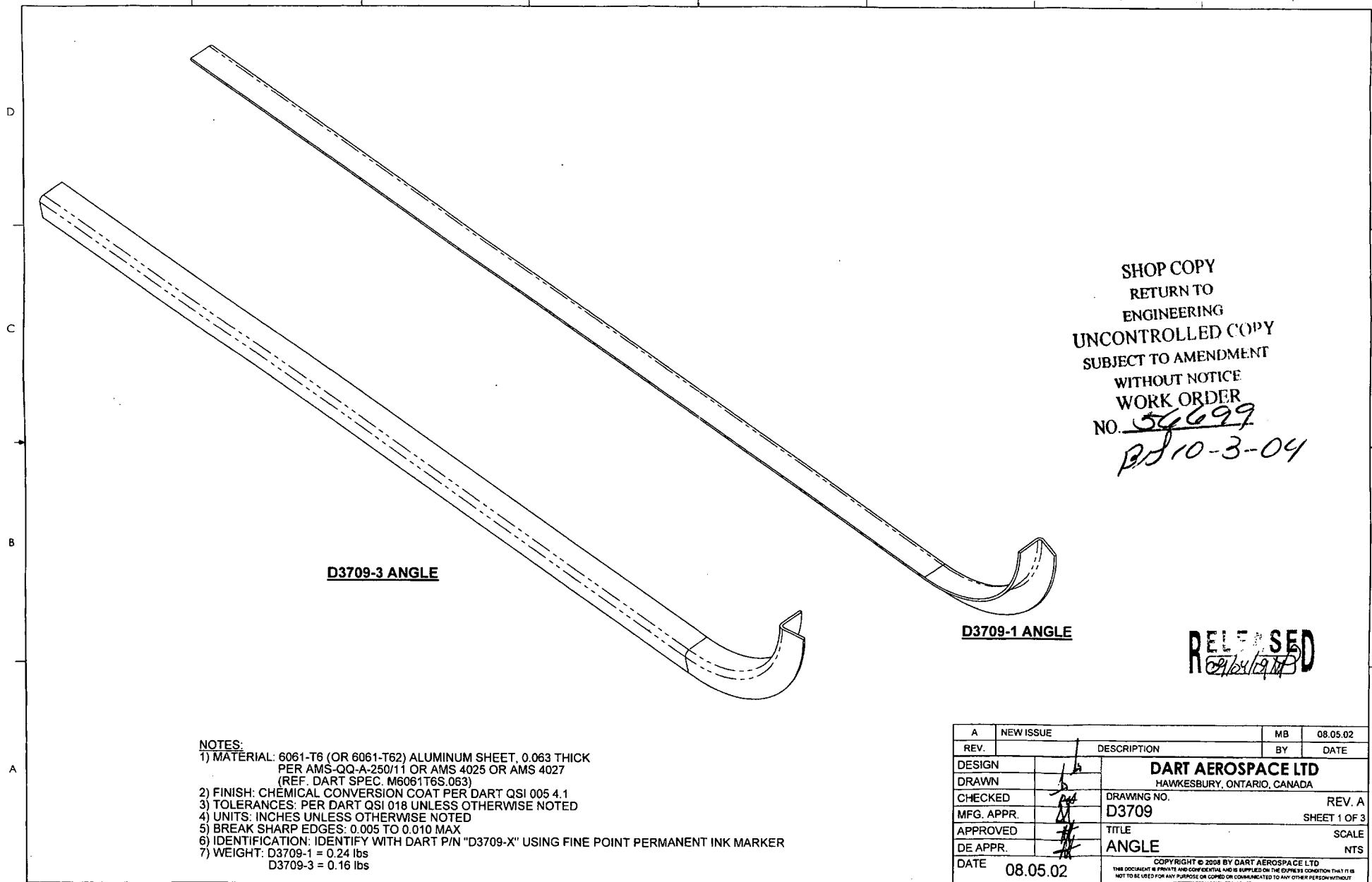
# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	HB	Audited by:	S	Prototype Approval:	N/A
Date:	10-3-10	Date:	10/03/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	10.02.02	New Issue	KJ	[Signature]

8 7 6 5 4 3 2 1



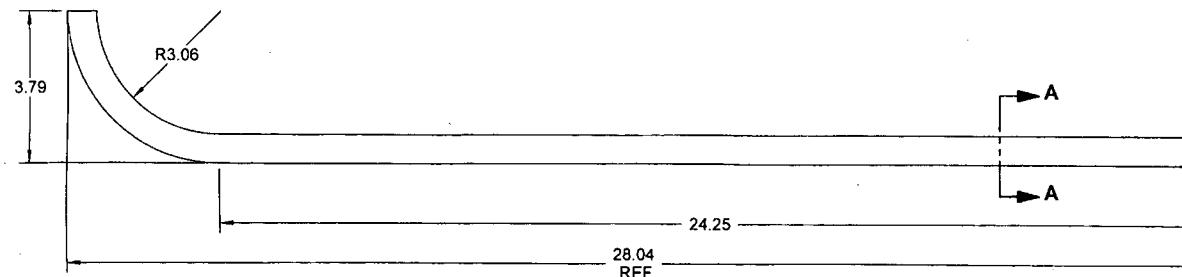
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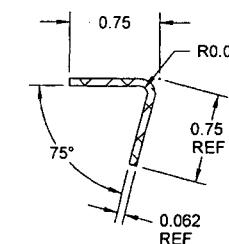
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D

D



**D3709-1 ANGLE**  
(MAKE FROM D3709-1F)



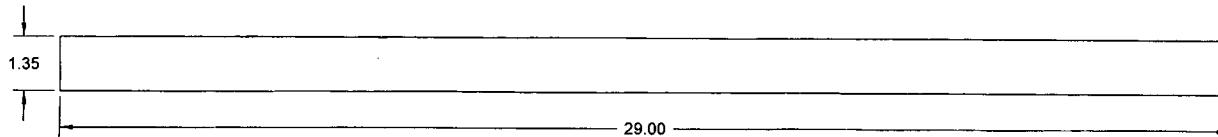
**SECTION A-A**  
SCALE 2X

C

C

B

B



**D3709-1F ANGLE FLAT PATTERN**

W0 56699

RELEASED  
09/09/09

A

A

DESIGN	15	DART AEROSPACE LTD	
DRAWN	15	HAWKESBURY, ONTARIO, CANADA	
CHECKED	15	DRAWING NO.	
MFG. APPR.	15	D3709	REV. A
APPROVED	15	SHEET 2 OF 3	
DE APPR.	15	TITLE	ANGLE
DATE	08.05.02	SCALE	NTS

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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

D

D

C

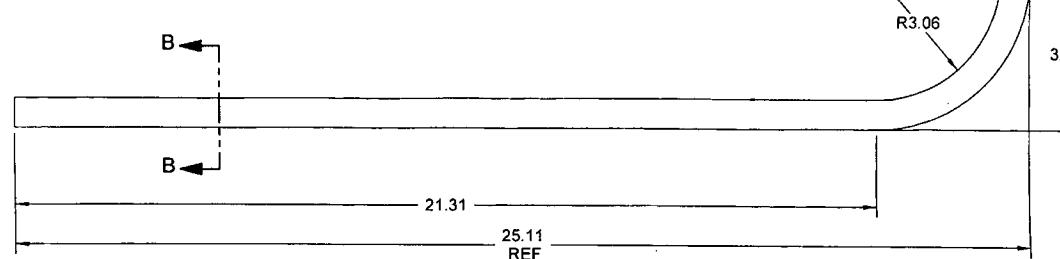
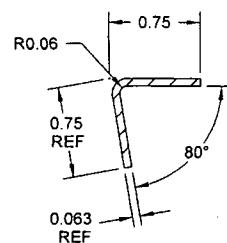
C

B

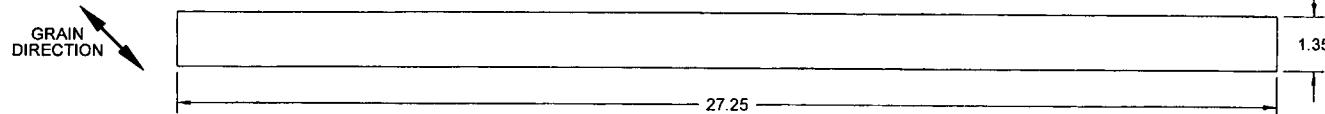
B

A

A



**D3709-3 ANGLE**  
(MAKE FROM D3709-3F)



**D3709-3F ANGLE FLAT PATTERN**

RELEASED  
07/04/09 JMF

wlo 56699

DESIGN	15	DART AEROSPACE LTD
DRAWN	15	HAWKESBURY, ONTARIO, CANADA
CHECKED	PL	DRAWING NO.
MFG. APPR.	MM	D3709
APPROVED	MM	REV. A
DE APPR.	MM	SHEET 3 OF 3
DATE	08.05.02	TITLE
		ANGLE
		SCALE
		NTS

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8 7 6 5 4 3 2 1